

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006127**Date Inspected:** 30-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Hong Fei & Li Zhi Jiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector performed Ultrasonic Testing (UT) on approximately 15% of CJP on the OBG 1AE welds previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QA Inspector observed no rejectable indications at the time of testing. The QA Inspector generated a TL-6027 UT report on this date. Welds UT verified were identified as listed below

Bay 2

SSD36-PP09.5-286

This QA Inspector observed the following work in progress:

Bay 10

ZPMC's qualified welding personnel is identified as Mr. Jiang Xiaohu (066155) perform FCAW (repair) welding on weld joint identified as SSD1-A111B/H-124A. ZPMC QC identified Mr. Chen Likun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-2G (2F)-Repair.

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ZPMC's welding personnel's are identified as Mrs. Zhang Lingling (207746) and Mrs. Liu Xianoyan (207745) performing groove welding of weld joint SSD1-FDSA3-1B/C-32B and SSD1-FCSA3-1B/C-3B. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. ZPMC QC identified Mr. Wan Wenzhong and was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3C-S-1.

ZPMC's qualified welding personnel's are identified as Mr. Shi Xingyu (052930) perform SMAW (repair) welding on weld joint identified as SSD1-TL5B/L-4A/B. ZPMC QC identified Mr. Wu Zhi Feng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair.

This QA Inspector observed ZPMC welder Fang Kaiyuan (040267) welding SSD1-TL5 H/L-17 without preheating material to the minimum temperature per approved WPS. QA Inspector issued an incident report on this date for the welding observed.

Bay 11

ZPMC's qualified welding personnel is identified as Mr. Wei Xiengli (067499) perform FCAW welding on weld joints identified ED1-A29A/B-17 and 7. ZPMC QC identified Mr. Chen Likun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

Bay 7

ZPMC's qualified welding personnel's are identified as Mr. Lu Xiujun (215259) and Jia Anquan (201725) perform SMAW welding on weld joints identified SP355-001-014, 013 and SP355-001-016 and 015. ZPMC QC identified Mr. Zhong Dian Xian was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2112.

ZPMC's qualified welding personnel identified as Mrs. He Yumei (048625) perform FCAW welding on weld joints identified SP505-001-046. ZPMC QC identified Mr. Xuxian Ping was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-B-U2-F.

Bay 6

ZPMC qualified welding personnel Mr. Dou Dexiang (048800) perform SMAW (repair) welding on weld joint identified as CB7-DP202-007-007 and 004. ZPMC QC identified Mr. Chen Chih Chien was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-(SMAW)-2G (2F)-repair.

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Bay 2

ZPMC's qualified welding personnel's are identified as Mr. Li Guoping (045251) and Mrs. Zhang Sumei (207464), Mrs. Gu Chunlan (048389), Mr. Ji Yi (045268) perform SMAW (tack) and welding on weld joints identified FB012-030-043, FB012-029-045, FB060-001-012,013, 007, 008, 017, 018 and FB062-002-007, 008, 017,018. ZPMC QC identified Mr. Li Zhi Jiang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2114 and WPS-B-P-2112-FCM.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
